

Work Order ID 112981

February-11-14 9:40:34 AM

Ship today

112981

Page 1

Item ID: D120-639-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate

Start Date: 2/11/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/11/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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DSI 9223	Rev A
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IIN-D120-639	Rev A
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MLS 14-02-11

100

0.00

100

DOCUMENT CONTROL

14-2-11

DAS

6

2x

②

DC

Memo

0.00

9-89

DOCUMENT CONTROL, Verify U

Photocopy bluefile and type labels per PPP D120-639-011 CHG 002

105

Pick Kit

0.00

105

Packaging

Memo

0.00

2x

DAS

28

9-89

14-02-11

DAS

31

9-89

Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 112981

February-11-14 9:40:34 AM

112981

Page 2

Item ID: D120-639-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 2/11/14 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 2/11/14 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									
120		0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Package and Identify as per PPP D120-639-011								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS

6

9-89

14-2-11

2

DAS

6

9-89

14-2-11

2

SHIP

14-02-11

NLF

14-2-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

February-11-14 9:40:33 AM

Page 1

Work Order ID: 112981
Parent Item: D120-639-011
Parent Item Name: Wearplate

Start Date: 2/11/14 Required Date: 2/11/14
Start Qty: 2.00 Required Qty: 2.00

Comments: IPP D 02.09.13 Re-format, Added MS27130-S30 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2746 Wearplate		Manufactured	No			105	Each	13.0000	1	2	DAS 28 9-89	14-02-11	
DAS 6 9-89				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					DAS 31 9-89
				ST500		13							
				86438		4							
				91907		9							
D2656-81 Wearplate Aft		Manufactured	No			105	Each	6.0000	1	2	DAS 28 9-89		
DAS 6 9-89				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					DAS 31 9-89
				FP002		6							
				105355		6							
D2656-49 Wearpad Fwd		Manufactured	No			105	Each	12.0000	1	2	DAS 28 9-89		
DAS 6 9-89				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					DAS 31 9-89
				ST500		12							
				101555		10							
				105308		2							
ALB7-1032-130 Rivnut	AELS8-1032-130	Purchased	No			105	Each	100.0000	36	72	DAS 28 9-89		
DAS 6 9-89				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					DAS 31 9-89
				FG		100							
				121444		100							
D2648-3 Wearpad		Manufactured	No			105	Each	19.0000	5	10	DAS 28 9-89		
DAS 6 9-89				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					DAS 31 9-89
				FG		8							
				85490		8							
				ST550		11							
				108785		10							
				34591		1							

Picklist Print

February-11-14 9:40:33 AM

Page 2

Work Order ID: 112981
Parent Item: D120-639-011
Parent Item Name: Wearplate

Start Date: 2/11/14

Required Date: 2/11/14

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-08
Screw

Purchased No

105 Each 829.0000 40 80

DAS
28
9-89

14-02-11

DAS
6
9-89

Location

Loc Qty

Loc Code

GA 39
m125654 39
st507 790
m127255 500
m127813 290

NAS1149D0352
Washer

Purchased No

105 Each 1,489.0000 40 80

DAS
28
9-89

DAS
31
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

GA 200
m127916 200
ST293 884
m127389 499
m127431 385
ST294 5
m125807 5
ST510a 400
m127916 400

MS27130-S30
Insert

Purchased No

105 Each 105.0000 4 8

DAS
28
9-89

DAS
31
9-89

D.S
6
9-89

Location

Loc Qty

Loc Code

ST310 105
100154 105

8x

DAS
31
9-89

DAS
6
9-89

4.0 WEIGHT AND BALANCE

The following weight and balance information is for the Dart wearplate kits that are being installed. The weight and balance of any wearplates that are being removed from the aircraft is the responsibility of the installer.

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D120-639-011 TUNGSTEN CARBIDE WEARPLATE KIT	3.1 lb 1.4 kg	136.0 in 3.45 m	422 in lb 4.8 m kg	±40.7 in ±1.04 m	±126 in lb ±1.5 m kg
D120-639-013 SURFACITE™ WEARPLATE KIT	4.1 lb 1.8 kg	136.0 in 3.45 m	558 in lb 6.2 m kg	±40.7 in ±1.04 m	±167 in lb ±1.9 m kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D120-639-011	TUNGSTEN CARBIDE WEARPLATE KIT
	X	D120-639-013	SURFACITE™ WEARPLATE KIT
	1	D27461	WEARPLATE
	1	D2656-31	WEARPLATE
	1	D2656-13	WEARPLATE
5		D2648-3	WEARPAD
	5	D2648-7	WEARPAD
40	40	ALS7-1032-130 or AKS7-1032-130 or ALS4-1032-130 or AKS4-1032-130	INSERT
40	40	MS27039-1108	SCREW
40	40	AN960JD10L	WASHER

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Revision: A

Date: 00.12.11



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9223	REV. A SHEET 1 OF 1
DATE 01.11.19		TITLE WEARPLATE INSERTS	SCALE NTS
A	01.11.19	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS

IIN-D120-639 Rev. A

REF. CANADIAN STC SH01-25

FAA STC: SR01347NY

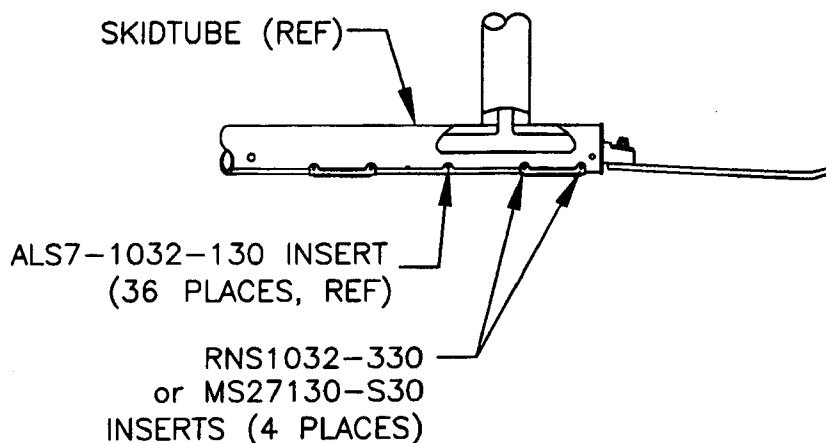
REPLACE (4) AFTMOST ALS7-1032-130 INSERTS WITH (4) RNS1032-330 / MS27130-S30 INSERTS.
UPDATE PARTS LIST AS FOLLOWS:

REPLACE:

QTY -011	QTY -013	Part Number	Description
40	40	ALS7-1032-130	INSERT

WITH:

QTY 011	QTY -013	Part Number	Description
36	36	ALS7-1032-130	INSERT
4	4	RNS1032-330 or MS27130-S30	INSERT



NOTE: OPEN HOLES TO $\phi 0.250$ INSTEAD
OF $\phi 0.297$ FOR THESE 4 INSERTS

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	NOV 19, 2001
CERT. NO.:	SH01-25
ISSUE NO.:	1

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Ship February

Work Order ID 112981

112981

February-11-14 9:40:34 AM

Item ID: D120-639-011

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Revision ID:

Item Name: Wearplate

Start Date: 2/11/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/11/14 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9223

Rev A

IIN-D120-639

Rev A

0.00

100

100

DC

DOCUMENT CONTROL, Verify U

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels per PPP D120-639-011 CHG 002

ML5 14-02-11

2

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging